DSBROWN

Production Joint Welding Procedure Specification (D1.5-02)

Procedure No: **A-(MC)G-SEALWELD-01** Date Issued: 9-29-04 Revision No: 0 Rev. Date: ___________

Contractor (Fabricator) D. S. Brown Company Prepared by: James R. Connor, Quality Assurance Manager

1. Non-Fracture Critical [X] Fracture Critical [ ] WPS Expiration Date: ________
2. Qualified in accordance with: AWS D1.5- 2002 (5.12.1)
   Referenced PQR No(s). PQR-(MC)GMAW-01(04) __ , __ , ____
   Referenced FWST No(s). PQR-(MC)GMAW-FWST-01A(04) , PQR-(MC)GMAW-FWST-01B(04) , __ , __
3. Material specification(s) ASTM A709 Gr. 36, 50, 50W
4. Material Thickness (es) Unlimited
5. Welding process GMAW
6. Manual [ ] , machine [ ] , or semiautomatic [X]
7. Position(s) of welding 1G, 2G, 1F, 2F
8. Filler metal specification AWS A5.18
9. Filler metal class and brand name E70C-6M Corex Metal-Core Maxim
10. Flux class & brand N/A , Type N/A
11. Shielding gas 75% Ar / 25% CO2 Flow rate 45 CFH
12. Single pass [X] Or multiple pass [X]
13. Single arc [X] Or multiple arc [ ]
14. Welding Current DCEP
15. Polarity Reverse
16. Welding progression stringers
17. Root treatment Clean to bright sound metal or per AWS D1.5 (3.2.1 & 3.11)
18. Postheat treatment N/A
19. Calculated Heat Input (KJ/In) Min 30.6 Kj/in Max 51.1 Kj/in
20. Electrode extension (electrical stickout) 3/4"

For DOT Approval

V.A.O.T.
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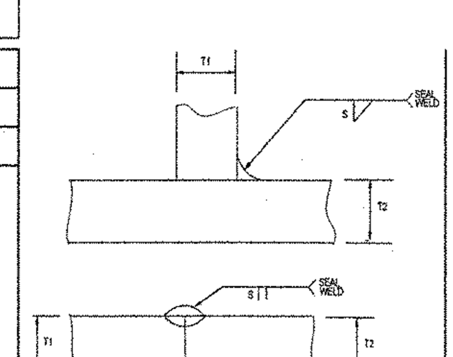
BY ____ DATE 11-30-04

Weld size (In)	Pass No(s).	Electrode Size (In)	Welding Process Variables		Travel Speed (IPM)
			AMPS	VOLTS	
**1/8"	1	.052"	265-320	31-34.5	13-16
**3/16"	1	.052"	265-320	31-34.5	13-16

NOTE:
THIS JOINT DETAIL TO BE ONLY USED FOR SEALING NON-STRUCTURAL APPLICATIONS WHERE FULL SIZED WELDMENTS ARE NOT DESIGNED, DETAILED OR ARE NOT PRACTICAL.

Joint Detail (Fillet)

Show all dimensions, weld sizes, passes, and AWS symbols



T1 = Varies
T2 = Varies
S = Weld Size

Prepared By: *James R. Connor* DSB QA Manager

Project: Granite Street over Stevens Branch of the Winooski River

DSB Job: 12550-1042

Preheat and Interpass Temperature Chart		
Base Metal Thickness range	Minimum Preheat (°F)	Max Preheat & Interpass (°F)
≤ 3/4"	50°F	450°F
>3/4" to ≤1.5"	70°F	450°F
>1.5" to ≤2.5"	150°F	450°F
>2.5"	225°F	450°F

Note: When this procedure is used for A709Gr50W materials, it shall be limited to 5/16" single pass or material be coated.

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